

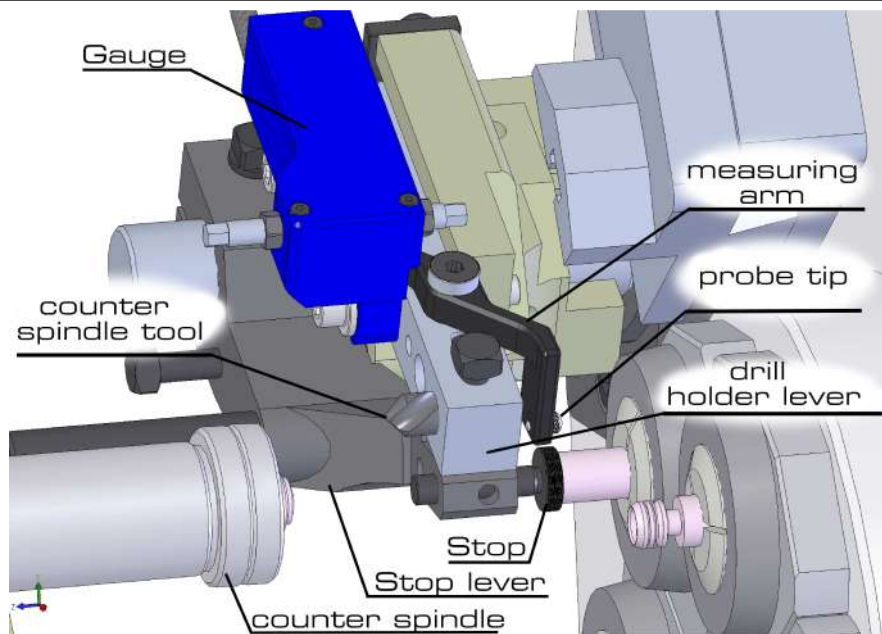
User guide

L00A

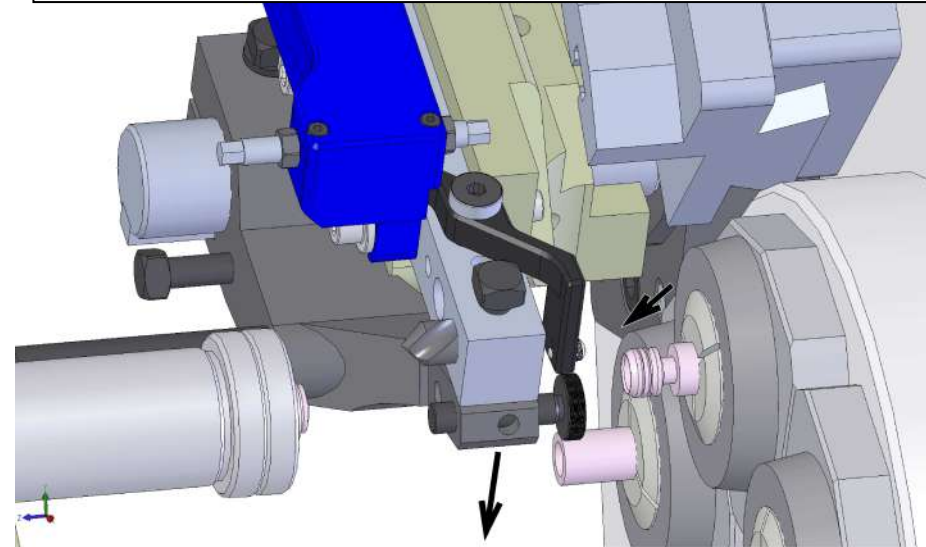
www.detector-france.com

INSL00AEN – indice A

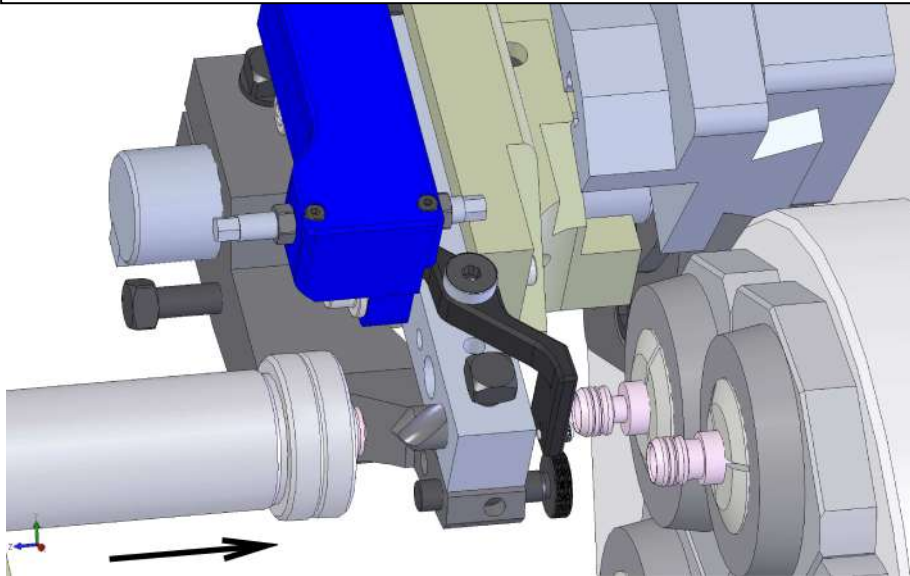
How does the L00A gauge work?



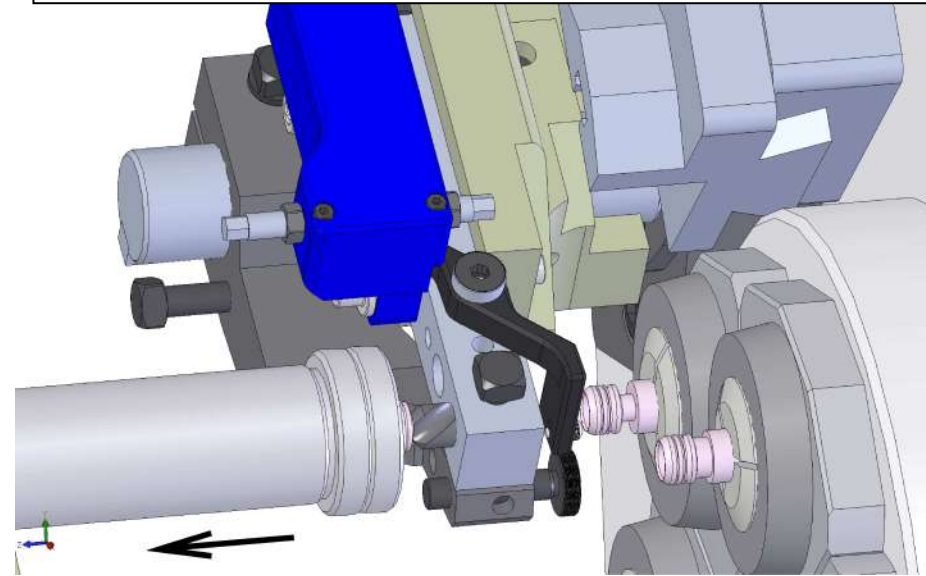
1 – Drum indexing + drill-holder goes down into position



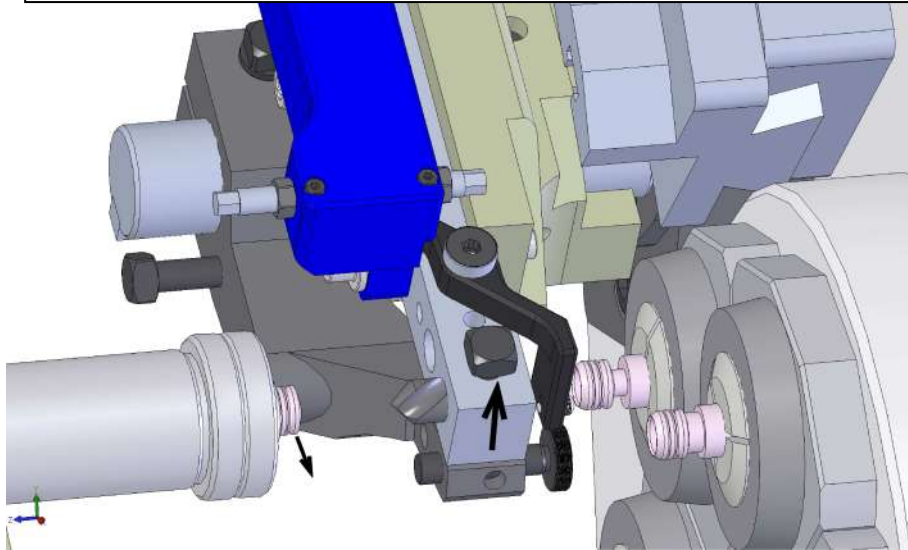
2 – Counter operation - Approach



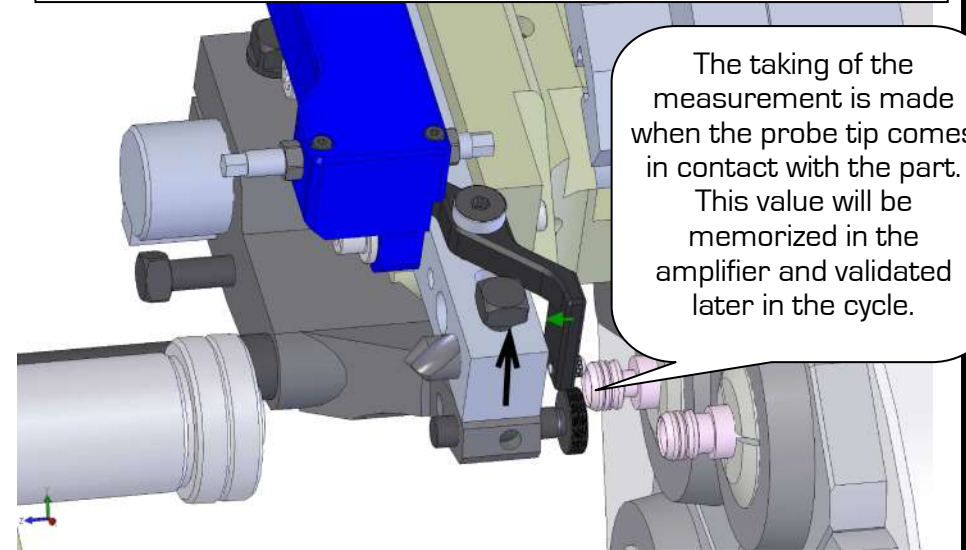
3 – Counter operation - Retraction



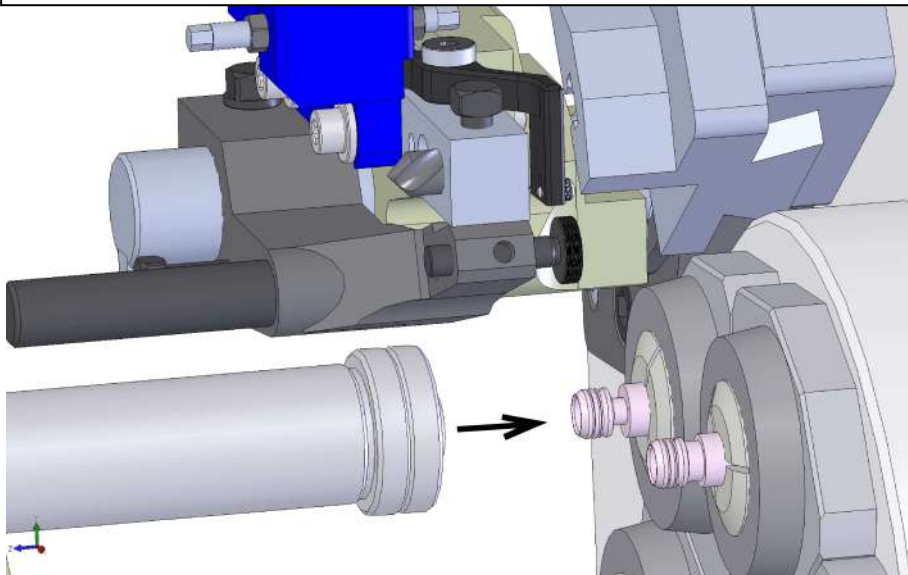
4 – Part ejection + drill holder goes up out of work area



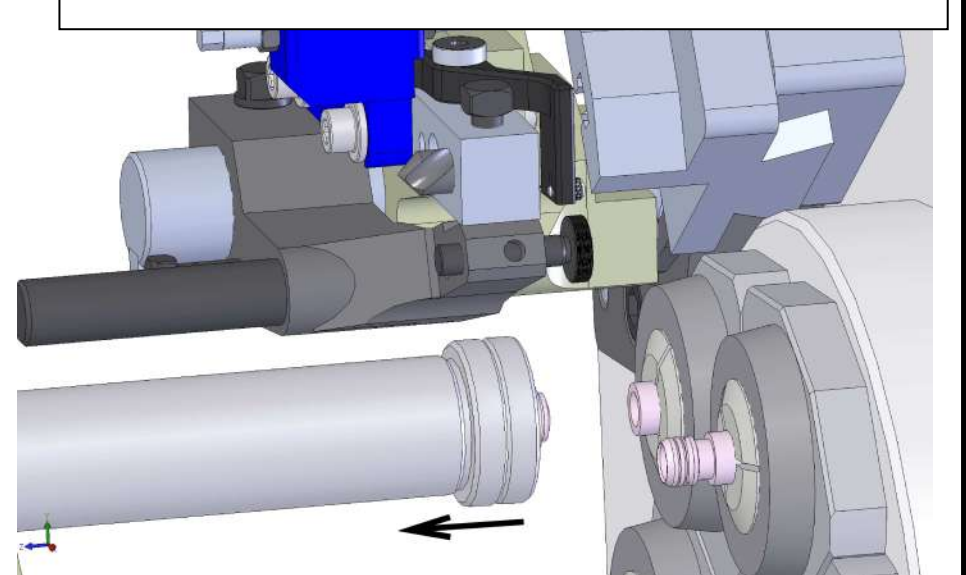
5 – Part measurement as drill holder moves out the work area



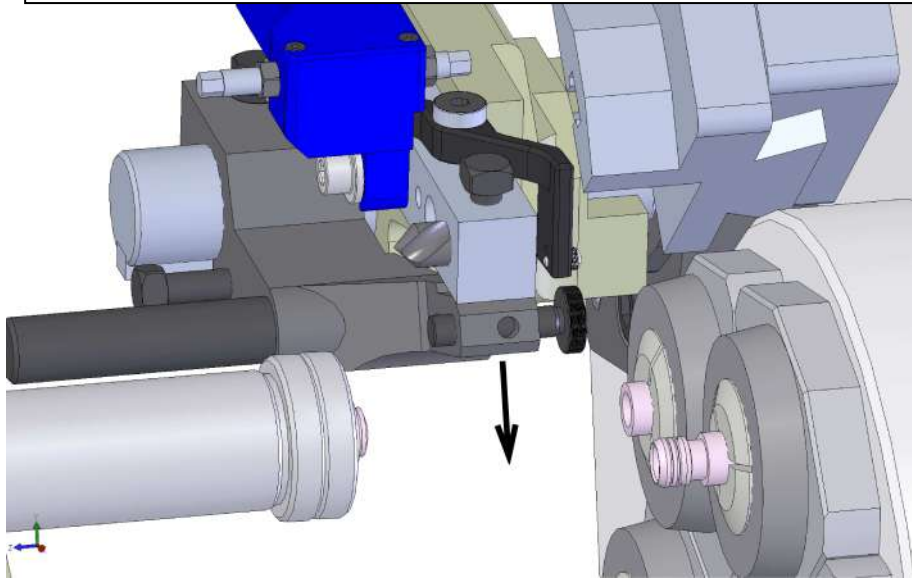
6 – Taking of the part - Approach



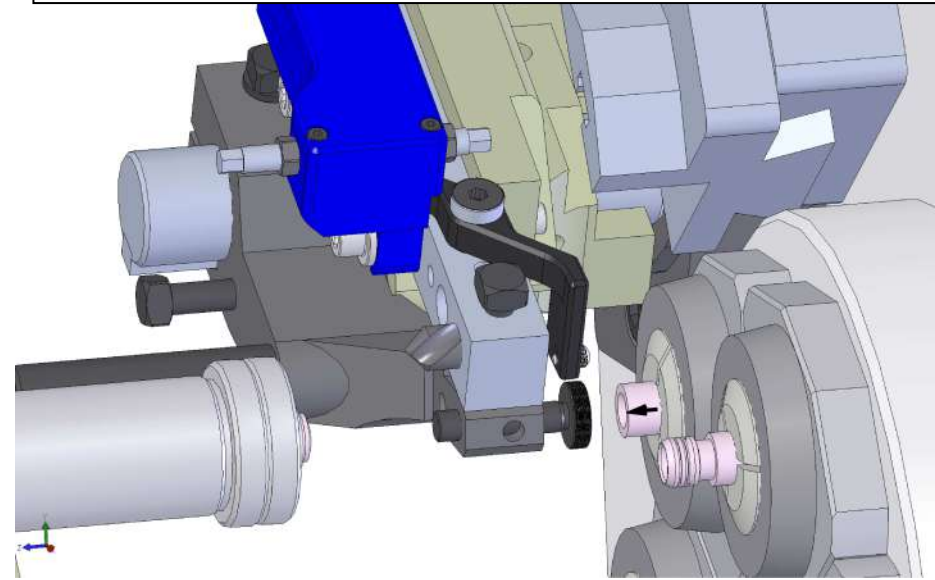
7 – Cutting – Retraction of the counter spindle



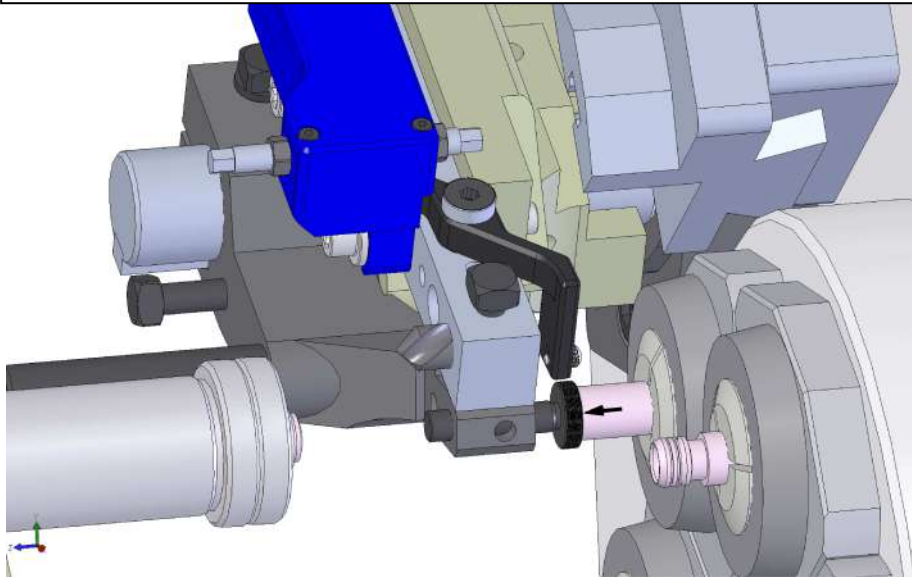
8 –drill holder goes down into position



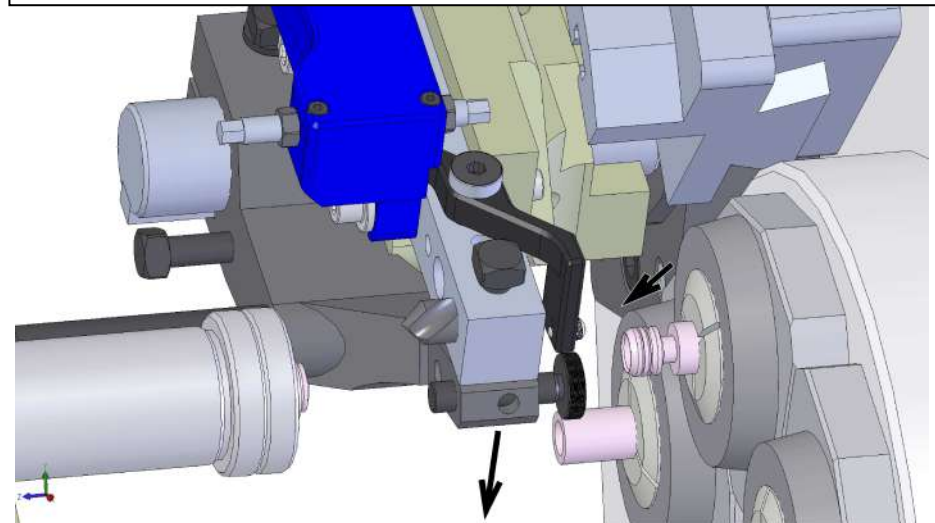
9 –Bar feed



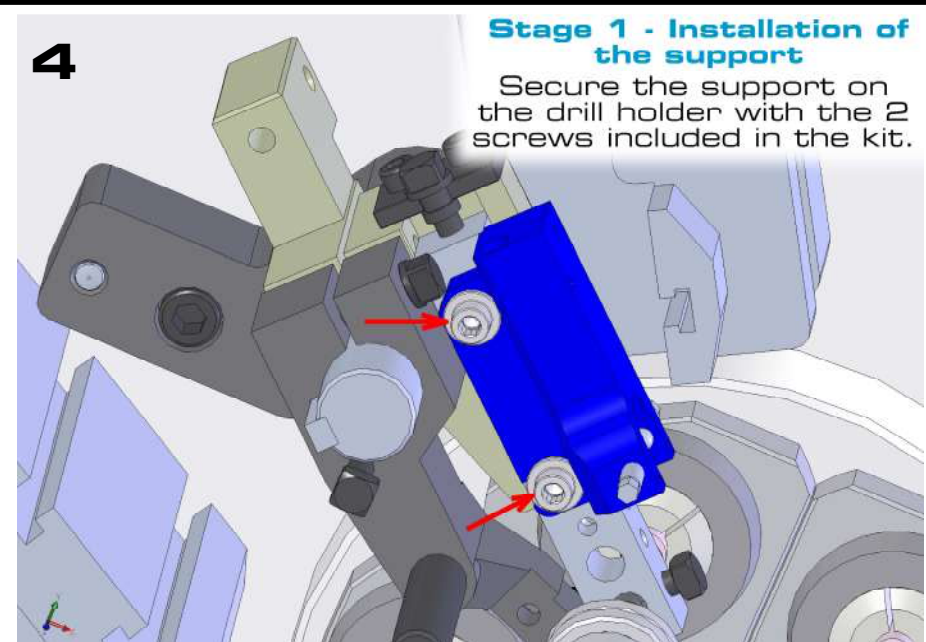
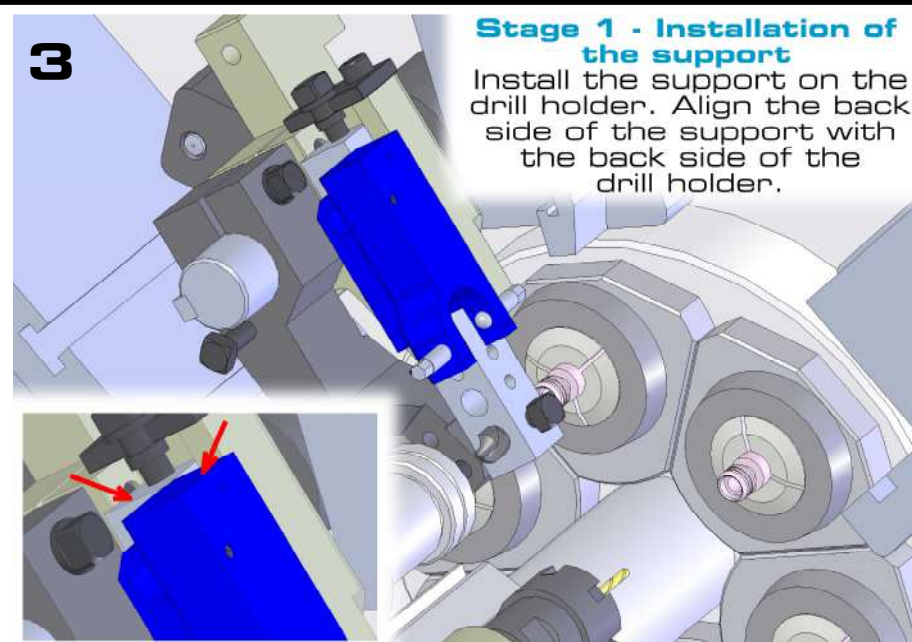
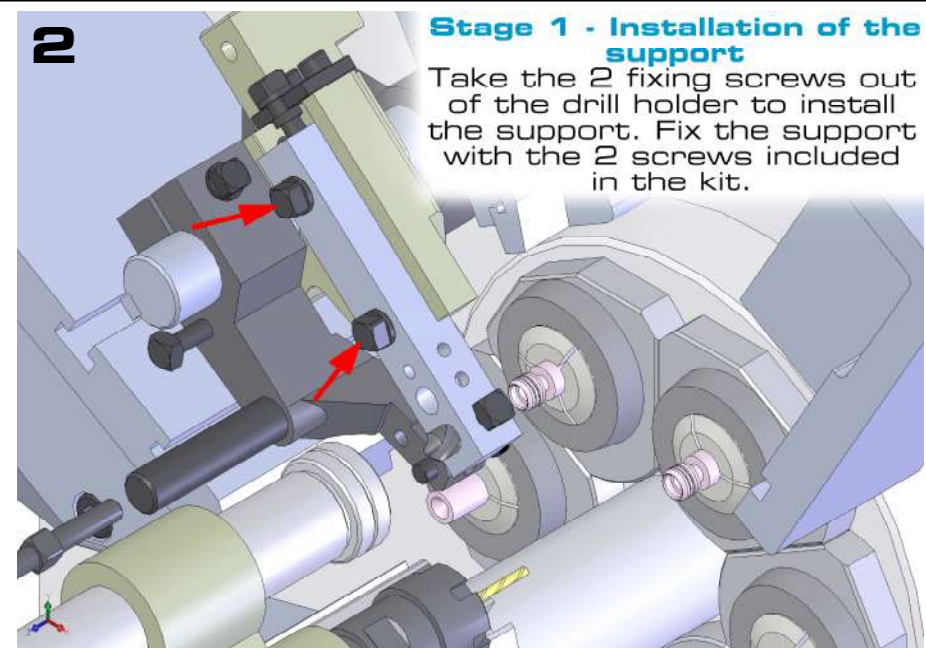
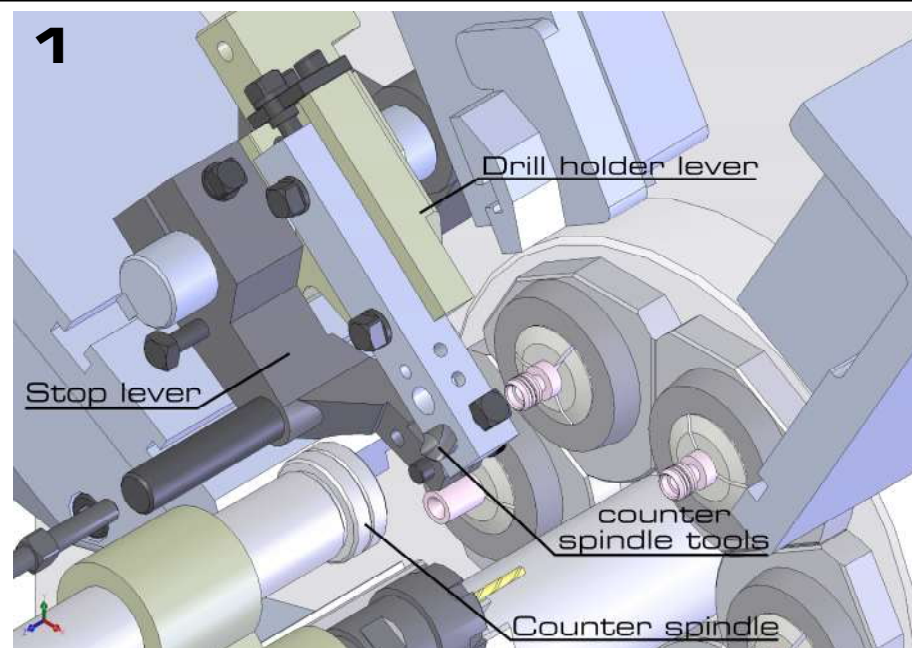
10 – Bar comes up against the stop



11 – Drum indexing + drill holder goes down into position



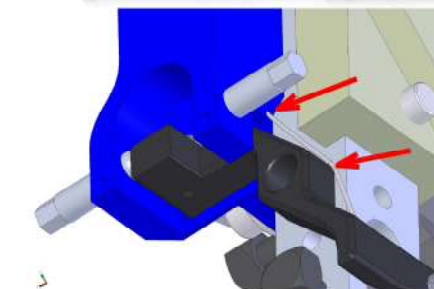
Mechanical installation and adjustment of the L00A gauge



5

Stage 2 - Installation of the lever

Install the lever on the drill holder.

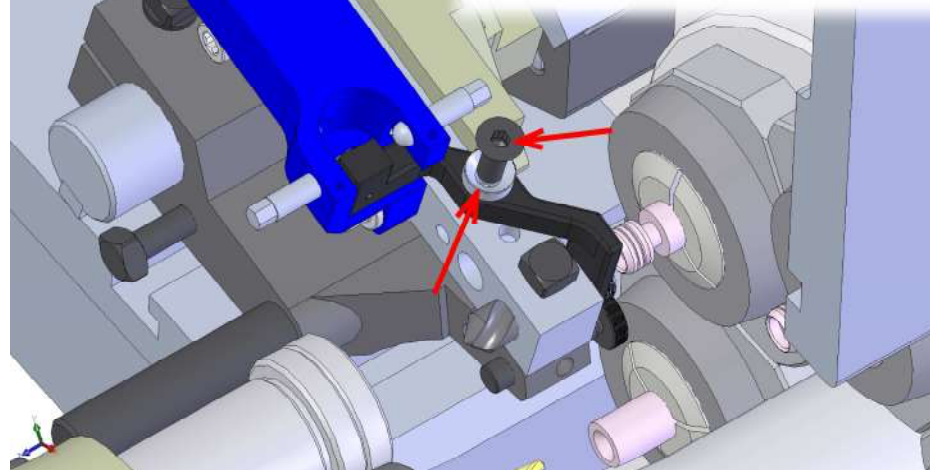


Put the spring in the small hole so that it is under tension. Make sure that the spring is not caught between the drill holder and the measurement lever.

6

Stage 2 - Installation of the lever

Place the guide ring in the lever and lock the position with the screw FHC.

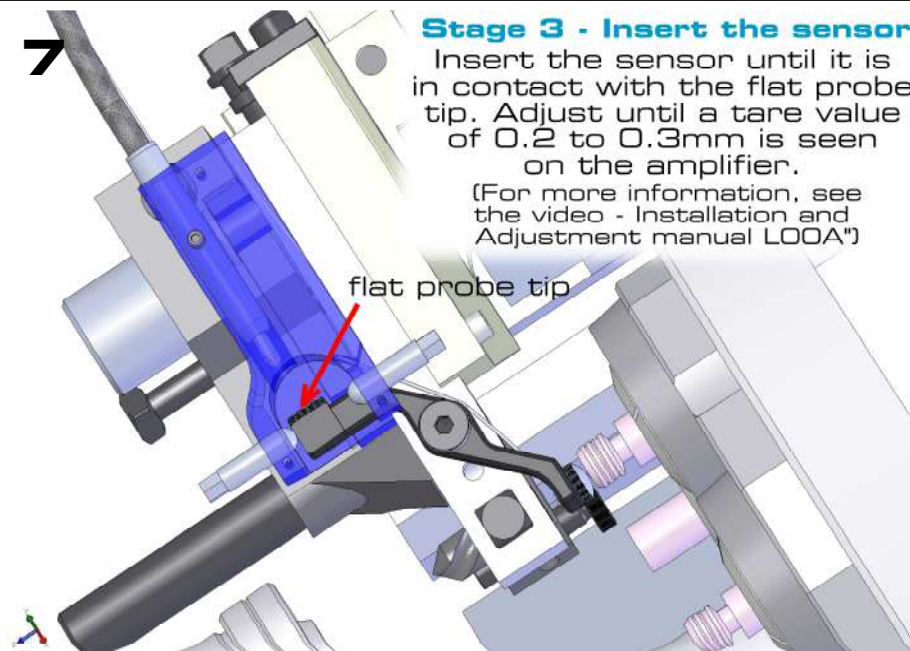


7

Stage 3 - Insert the sensor

Insert the sensor until it is in contact with the flat probe tip. Adjust until a tare value of 0.2 to 0.3mm is seen on the amplifier.

(For more information, see the video - Installation and Adjustment manual L00A")



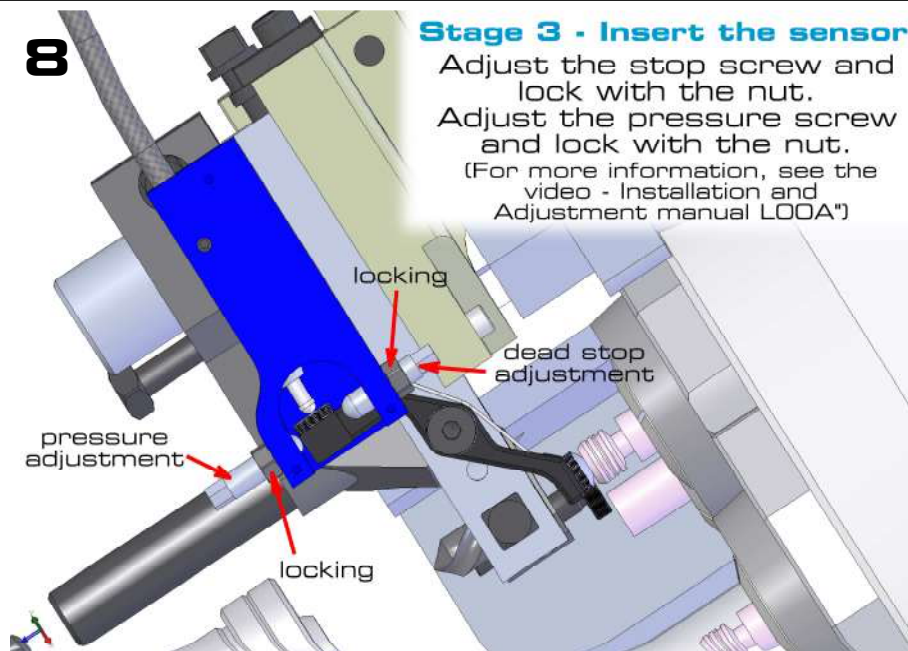
flat probe tip

8

Stage 3 - Insert the sensor

Adjust the stop screw and lock with the nut. Adjust the pressure screw and lock with the nut.

(For more information, see the video - Installation and Adjustment manual L00A")



locking

dead stop adjustment

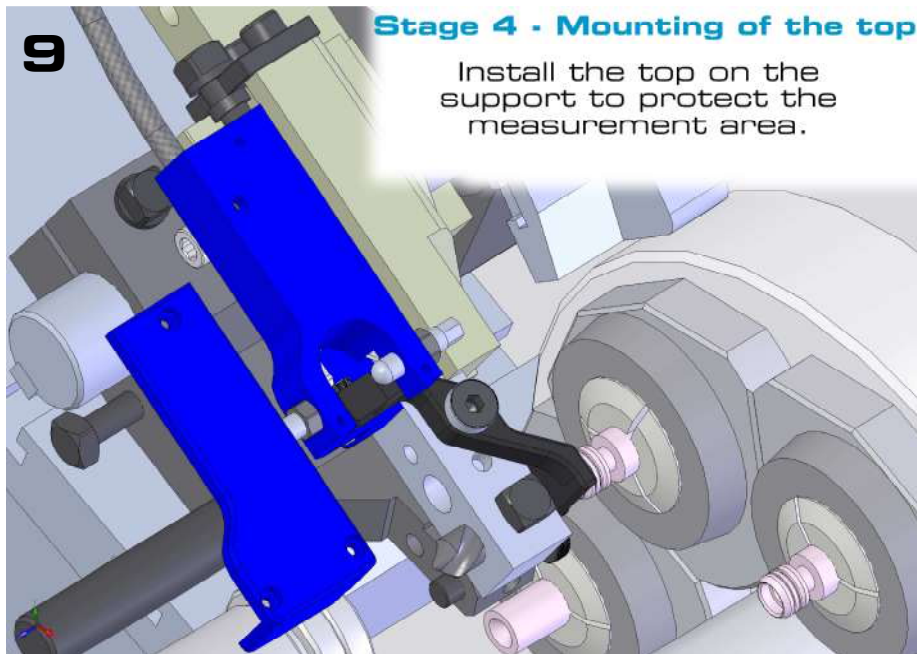
pressure adjustment

locking

9

Stage 4 - Mounting of the top

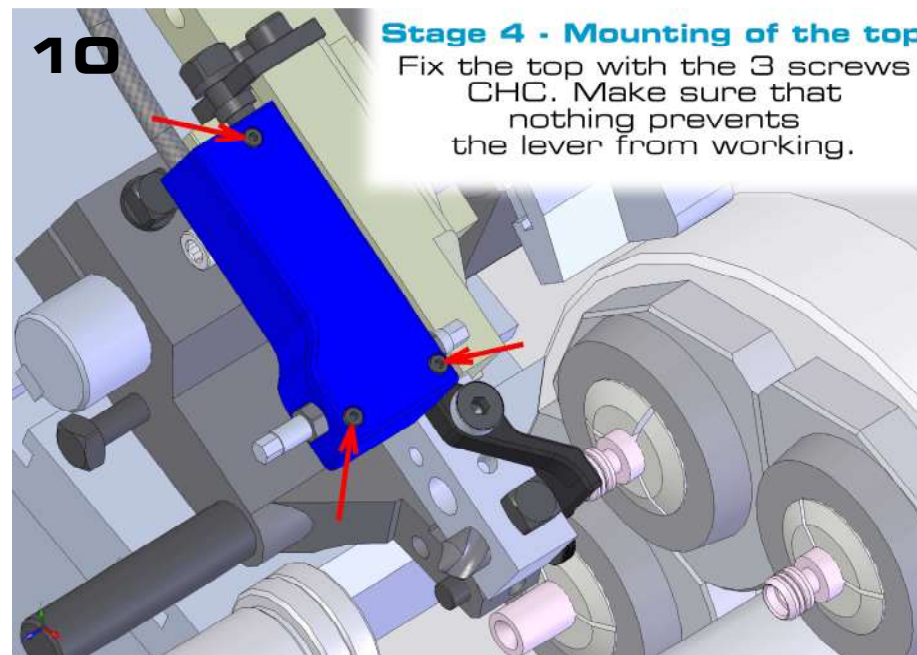
Install the top on the support to protect the measurement area.



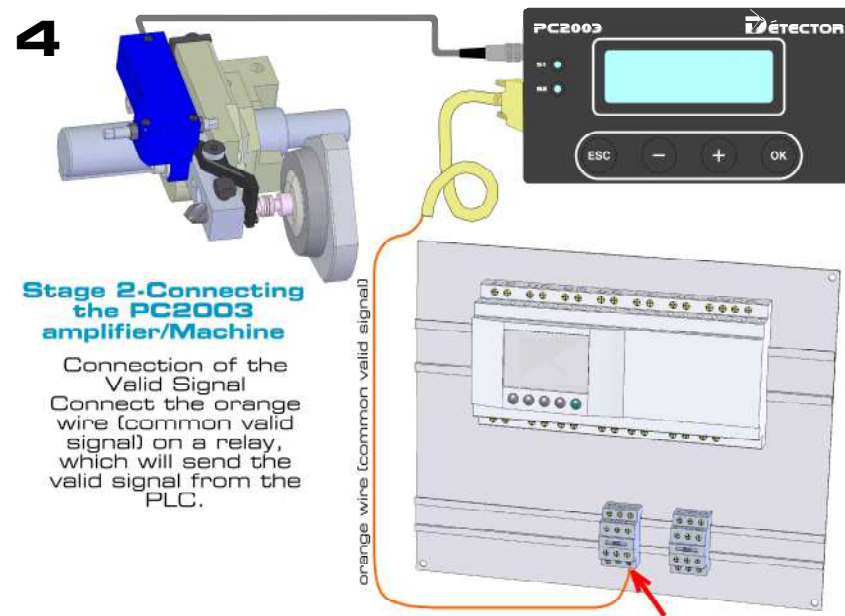
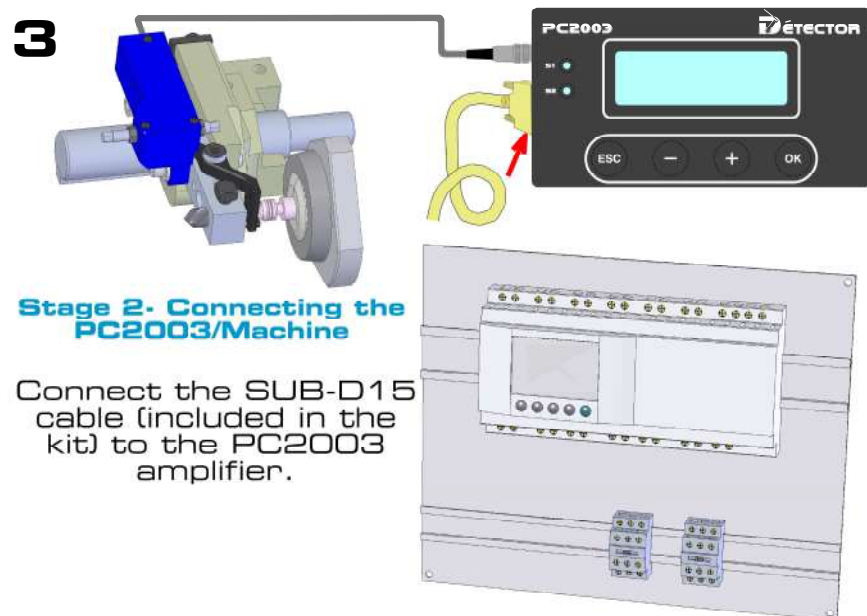
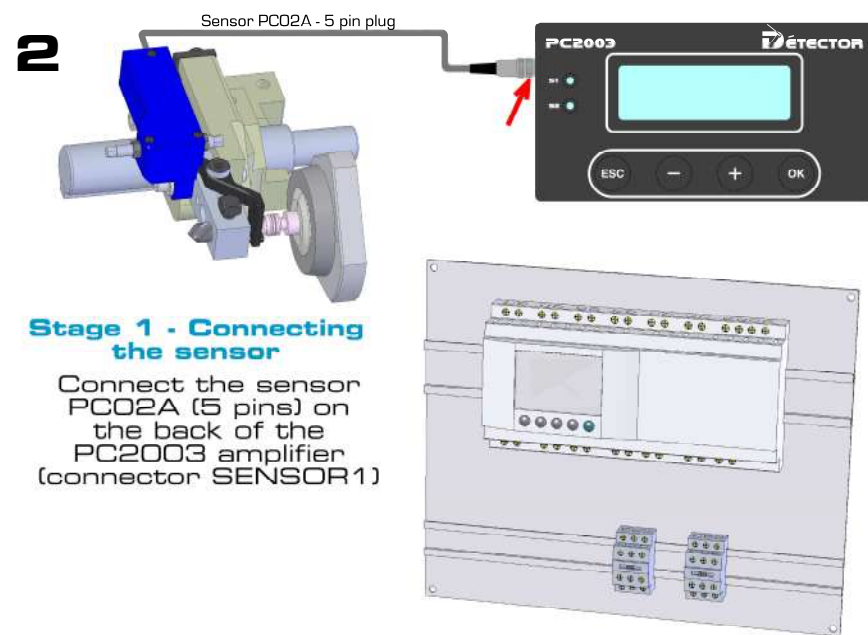
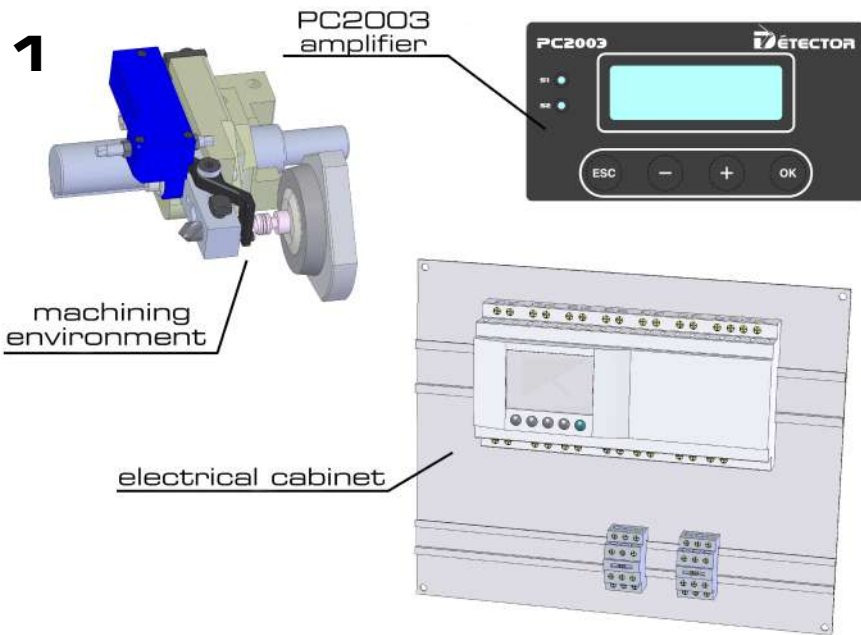
10

Stage 4 - Mounting of the top

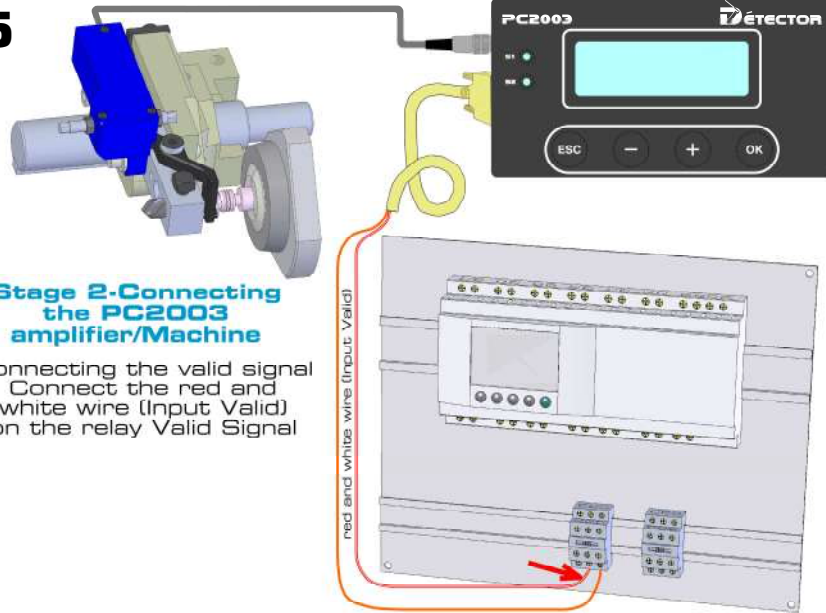
Fix the top with the 3 screws CHC. Make sure that nothing prevents the lever from working.



Electrical connection of the PC2003



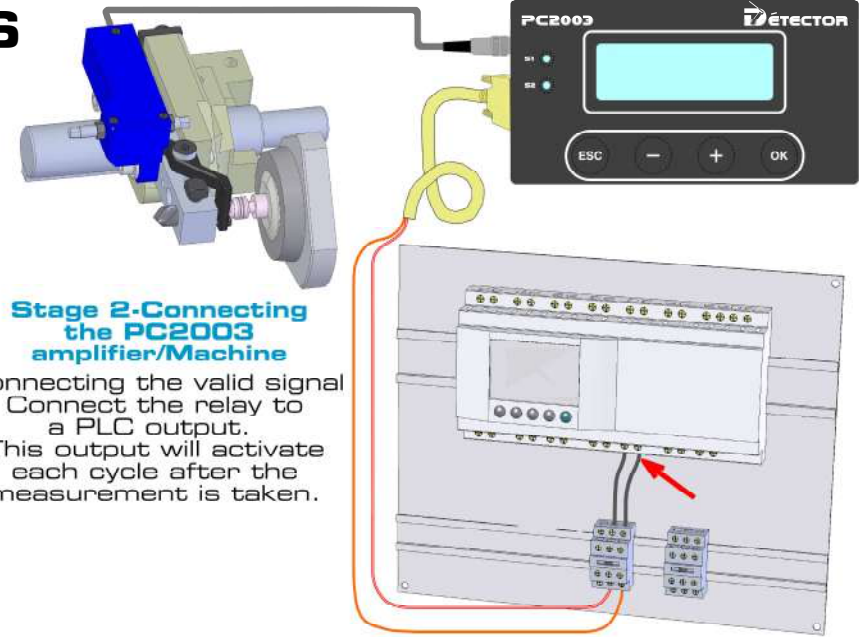
5



Stage 2-Connecting the PC2003 amplifier/Machine

Connecting the valid signal
Connect the red and white wire (Input Valid) on the relay Valid Signal

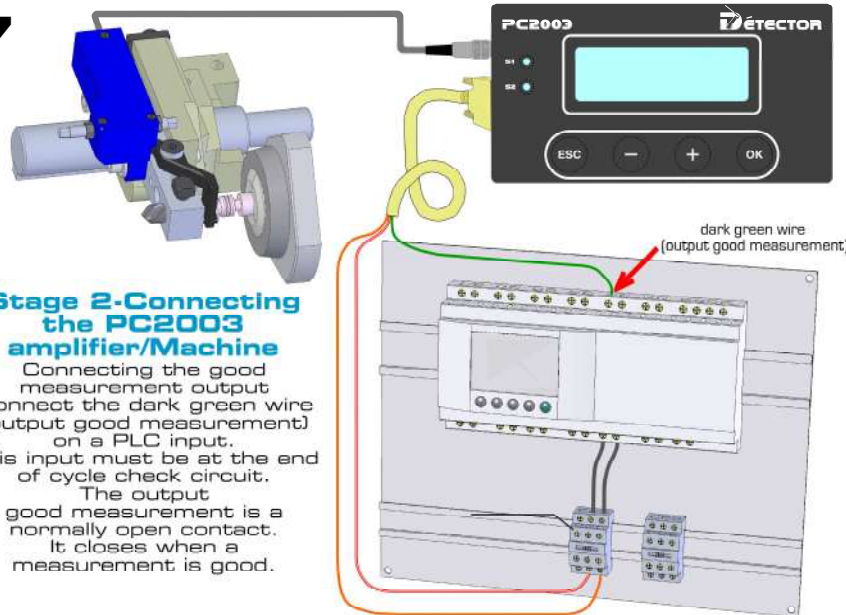
6



Stage 2-Connecting the PC2003 amplifier/Machine

Connecting the valid signal
Connect the relay to a PLC output.
This output will activate each cycle after the measurement is taken.

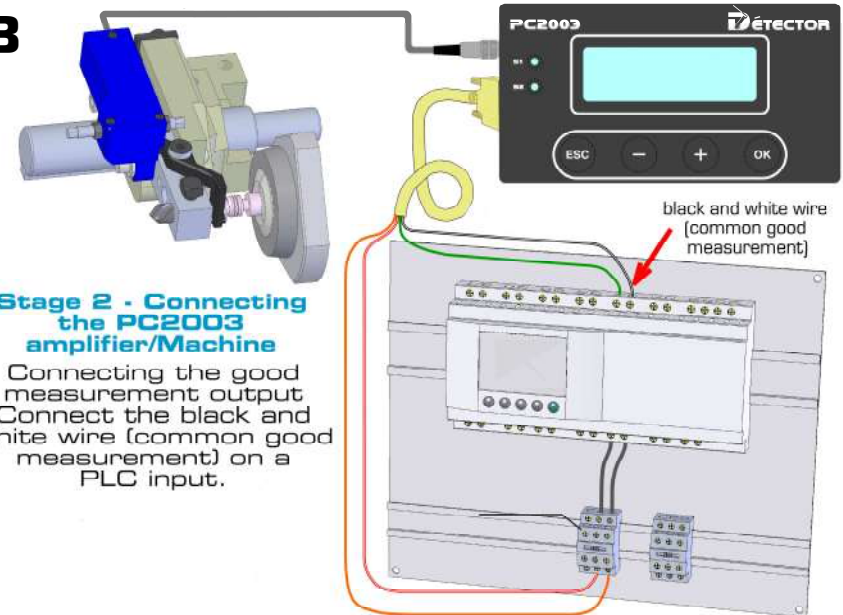
7



Stage 2-Connecting the PC2003 amplifier/Machine

Connecting the good measurement output
Connect the dark green wire (output good measurement) on a PLC input.
This input must be at the end of cycle check circuit.
The output good measurement is a normally open contact. It closes when a measurement is good.

8



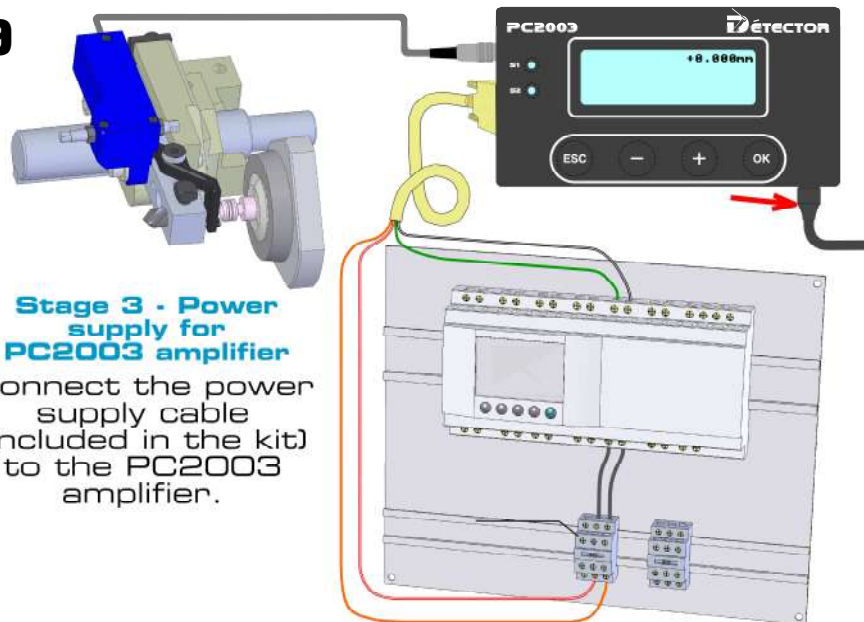
Stage 2 - Connecting the PC2003 amplifier/Machine

Connecting the good measurement output
Connect the black and white wire (common good measurement) on a PLC input.

9

Stage 3 - Power supply for PC2003 amplifier

Connect the power supply cable (included in the kit) to the PC2003 amplifier.





Manufacturer

DETECTOR FRANCE

36 route des lacs – PAE des Jourdiés

74800 Saint Pierre en Faucigny

Tél : 00 33 (0)450 037 998

Fax : 00 33 (0)450 036 792

Email : commercial@detector-france.com